

Date: Monday, 1/7/2008 3:39:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUFF	X P. 08.01.08 7/8 Um: Each
Job Number : 36651	Part Number : D36601	
Estimate Number : 13023	Drawing Number : D3660 UNDER REV	
P.O. Number :	Project Number : N/A	
This Issue : 1/7/2008 S.O. No. :	Drawing Revision : U/R	
Prsht Rev. : NC	Material :	
First Issue : 1/1 Type : MACHINED PARTS	Due Date : 1/31/2008	
Previous Run : 34716		
Written By : <u>[Signature]</u>		
Checked & Approved By : <u>[Signature]</u>		
Comment : est rev A new issue 07.09.19 EC verified by:JLM		

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6009129P	Crosstube Material
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D6009129P 2008/12/08



Comment: Qty.: 0.3460 Each(s)/Unit Total : 2.0759 Each(s)

D6009-129 X-TUBE MATERIAL

batch: B25667

* 080116

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Machined Manually

Pto

1-Turn as per folio FA 708 & DWG D3660,

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

* 080116 (7)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

* 080116 (7)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 080117 (x7)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HJ 08-01-24

(V7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/88
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.01.17	2	<p>Ø2.990 DIM IS 2.988 ON TWO PARTS</p> <p>Ø2.695 DIM IS 2.694" ON ONE & 2.692 ON OTHER</p>	<p>P</p> <p>08.01.17 J~</p> <p>ØS1042</p>	PARTS ACCEPTABLE	<p>P</p> <p>080117</p>	<p>↓</p> <p>08/01/17</p>	<p>P</p> <p>08.01.17 PL</p> <p>ØS1042</p>	<p>↓</p> <p>08/01/17</p>

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:39:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUFF

Job Number: 36651

Part Number: D36601

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/08 (47)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 479

6 Dec P

8/2/8

50

(1x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

Job Completion



POSITIVE RECALL

EFFECTIVE 08.01.08 AUTH CP

RELEASED CP DATE 08.02.07

2008/2/08

(7)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

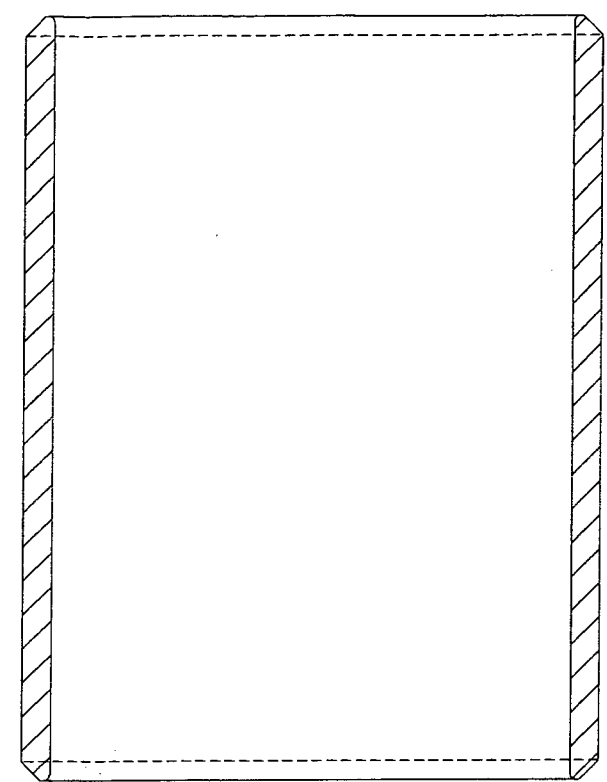
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

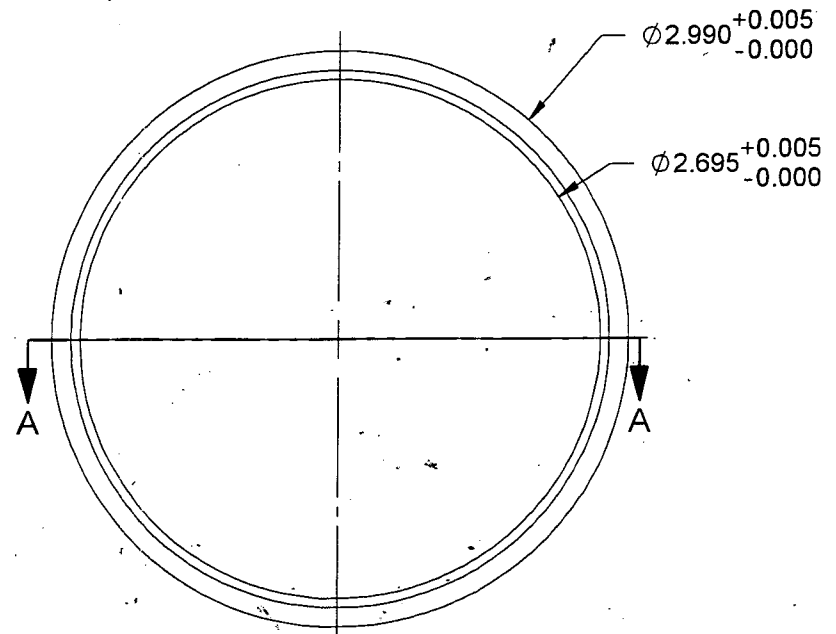
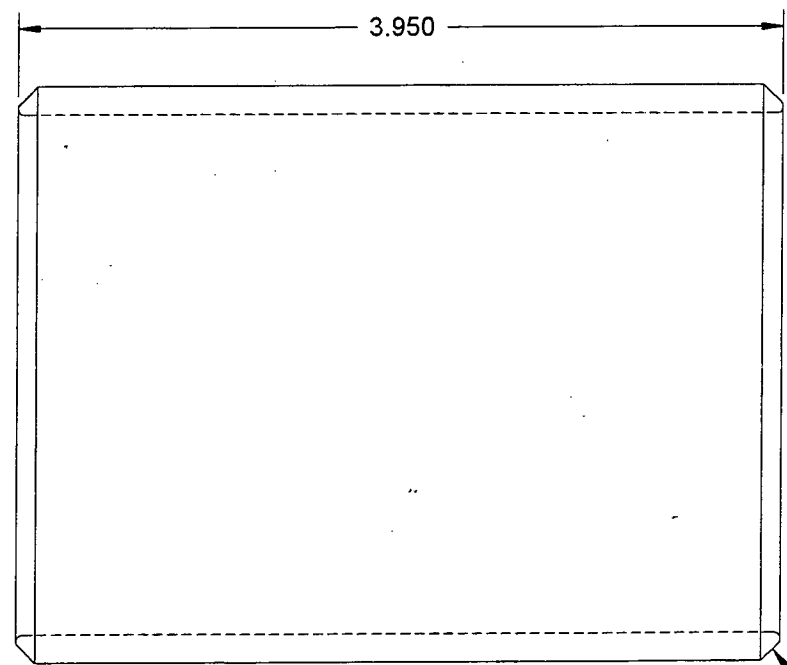
NOTE: Date & initial all entries

chairs.
I have two (2) parts
that are under the
tol.
1- outside 2.988"
 ? inside 2.694"
2- { outside 2.988/2.989"
 inside 2.692"
what's your op. on.

SECTION A-A



R0.032
(TYP INSIDE EDGES)

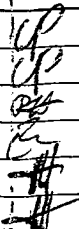



CHAMFER 0.100 x 45°
(TYP OUTSIDE EDGES)

D3660-1 CUFF

- NOTES:
- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.52 lbs

PRELIMINARY ISSUE
08.07.07
OK 08.02.07
RELEASED
07.09.24

A		New Issue		CP		07.07.07			
REV.		DESCRIPTION				BY		DATE	
DESIGN				DART AEROSPACE LTD					
DRAWN				HAWKESBURY, ONTARIO, CANADA					
CHECKED				DRAWING NO.				REV. A	
MFG. APPR.				D3660				SHEET 1 OF 1	
APPROVED				TITLE				SCALE	
DE APPR.				CUFF				1:1	
DATE				07.07.07					
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DART AEROSPACE LTD	Work Order:	36651
Description: Cuff	Part Number:	D3660-1
Inspection Dwg: D.3660 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	<i>n</i>
Date:	08/01/16	Date:	08-01-16	Date:	<i>7</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	